



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2891-1
Job Sheet 214975



Part No: D2891-1

Job Qty: 8 pcs *20 pcs MK*

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/3/20

Job Tracking No:

Due Date: 12/4/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2891 REV C IPP C 08.03.19 Re-format EC verified:DD/IPP Rev:E 11.08.04 as per dwg rev.B DD
verf:EC/IPP Rev.F 19.12.02 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	8 pcs	12/3/20		1.00	6.56	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	8 pcs	12/3/20		0.00	0.00	QC 2 - 1		<i>SL / D- 20-11-24</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		<i>SL 20-11-24</i>
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S316297



Part: D2891-1

Job No: 214975

Serial No/Batch: S316297

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/26/20

Plex 11/3/20 1:15 PM Dart.lajeunesse.marie

					QC 2 - 8	B. 20-11-24
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
120	QC 8	8 pcs	12/3/20	0.00 0.00	QC 8 - 20	St 20-11-29
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Crosstubes - 2 - B4B	8 pcs	12/4/20	0.00 0.38	Crosstubes - 1 - B4B	DAG 41 DEC 13 2020 8-89
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	
140	QC 3	8 pcs	12/4/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	

				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		DAS 41 DEC 04 2020 9-89
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
				QC 3 - 82		
				QC 3 - 87		
				QC 3 - 47		
170	Packaging 3-1 - Stock - B4B	8 pcs	12/4/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	DAS 41 DEC 04 2020 9-89
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS 21 DEC 04 2020 9-89
180	QC 21 - SA	8 pcs	12/4/20	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. ~~520677~~ exp. 3/21

140 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____ LOCATION : L0052 *L4050*
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	4 pcs (.5 ea)	100-HAAS 4 Axis	<i>S251416 X10</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK076	4	16	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010		
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290		
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454		
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779		
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002		
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257		
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663		
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

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DART AEROSPACE LTD		Work Order: 214975
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.188	.188	.188	.188	.188
AB	0.240	0.260		.250	.250	.251	.251	.250
AC	0.115	0.150		.125	.125	.125	.125	.126
AD	0.040	0.060		.049	.049	.047	.047	.049
AE	0.010	0.020		.015	.015	.015	.015	.015
AF	0.240	0.260		.250	.250	.250	.250	.250
AG	0.290 0.270	0.310 0.330		.310	.310	.310	.310	.310
AH	0.115	0.150		.138	.138	.138	.138	.139
AI	0.454	0.474		.461	.461	.464	.464	.461
AJ	2.779 ^H	2.788 ^{9H}		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	.250	.250	.250	.250
AL	1.002	1.042		1.033	1.036	1.035	1.034	1.034
AM	0.053	0.073		.063	.063	.063	.063	.063
AN	0.257	0.267 ³		.257	.257	.257	.257	.257
AO	1.663	1.683		1.670	1.670	1.675	1.675	1.674
AP	0.053	0.073		.063	.063	.063	.063	.063
AQ	0.022	0.042	0.053 - 0.073	.063	.063	.063	.063	.063
AR	0.220	0.280		.250	.250	.250	.250	.250
AS								
AT								
Accept/Reject								

Measured by: JL	Date: 20-11-20
Audited by: DAS 20 9-89	Date: 20-11-29
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 214975
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	27	38	49	510
HAAS Section								
AA	0.188	0.193		.188	0.189	0.189	0.189	0.189
AB	0.240	0.260		.248	0.247	0.245	0.245	0.246
AC	0.115	0.150		.126	0.126	0.126	0.126	0.126
AD	0.040	0.060		.049	0.051	0.048	0.049	0.049
AE	0.010	0.020		.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		.250	0.250	0.250	0.250	0.250
AG	0.290	0.310	0.330	.310	0.310	0.310	0.310	0.310
AH	0.115	0.150		.139	0.138	0.138	0.138	0.138
AI	0.454	0.474		.462	0.464	0.465	0.465	0.467
AJ	2.7794	2.7894		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.034	1.037	1.037	1.037	1.035
AM	0.053	0.073		.063	0.063	0.063	0.063	0.063
AN	0.257	0.2623		.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.675	1.674	1.675	1.676	1.675
AP	0.053	0.073		.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042	0.053-0.073	.063	0.063	0.063	0.063	0.063
AR	.220	.280		.250	0.250	0.250	0.250	0.250
AS								
AT								
Accept/Reject								

Measured by: D.e	Date: 20-11-24
Audited by: DAS	Date: 20-11-29
Preliminary Approval: 20	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 214975
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: BC	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AB	0.240	0.260		0.247	0.247	0.246	0.249	0.246
AC	0.115	0.150		0.126	0.126	0.126	0.126	0.126
AD	0.040	0.060		0.047	0.049	0.048	0.048	0.050
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290-0.290	0.340	0.330	0.310	0.310	0.310	0.310	0.310
AH	0.115	0.150		0.138	0.138	0.138	0.138	0.138
AI	0.454	0.474		0.470	0.466	0.467	0.465	0.465
AJ	2.7784	2.7894		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.038	1.036	1.038	1.034	1.039
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.2673		0.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.677	1.674	1.677	1.675	1.675
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042	0.053 / 0.073	0.063	0.063	0.063	0.063	0.063
AR	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AS								
AT								
Accept/Reject								

Measured by: B.e	Date: 20-11-25
Audited by: DAS	Date: 20-11-29
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 214975
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	20
HAAS Section								
AA	0.188	0.193		0.189	0.189	0.189	0.189	0.189
AB	0.240	0.260		0.246	0.247	0.246	0.250	0.250
AC	0.115	0.150		0.126	0.126	0.126	0.126	0.126
AD	0.040	0.060		0.049	0.047	0.050	0.049	0.048
AE	0.010	0.020		0.015	0.015	0.015	0.015	0.015
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290/0.270	0.340/0.330		0.310	0.310	0.310	0.310	0.310
AH	0.115	0.150		0.138	0.138	0.138	0.138	0.138
AI	0.454	0.474		0.466	0.466	0.466	0.466	0.465
AJ	2.7794	2.7894		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.037	1.038	1.036	1.037	1.039
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.2673		0.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.675	1.677	1.675	1.676	1.677
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042	0.053/0.073	0.063	0.063	0.063	0.063	0.063
AR	0.220	0.280		0.250	0.250	0.250	0.250	0.250
AS								
AT								
Accept/Reject								

Measured by: D.A.	Date: 20-11-25
Audited by: DAS	Date: 20-11-29
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					